

Universal RESEATER SET

WEATHERLY INDEX

MODEL R505

850

features:

- Simple to Operate
- Accurate — Precision Built
- Tool Steel Cutters
- Rugged Basic Design

RESEATER SETS AVAILABLE

R500	Basic Set (Manual Operated)
R501	Basic Set with R55B Power Drive
R502	Junior Set (Manual Operated)
R503	Junior Set with R55B Power Drive
R504	Universal Set (Manual Operated)
R505	Universal Set with R55B Power Drive



R504B Box is standard equipment for all sets. Space is provided in box for every part in the reseater line.



MODEL R504 UNIVERSAL RESEATER CONSISTS OF THE FOLLOWING

Designed to service 98 per cent of all makes of cars, trucks and tractors.

Model R504 Universal Reseater Set consists of the following items:

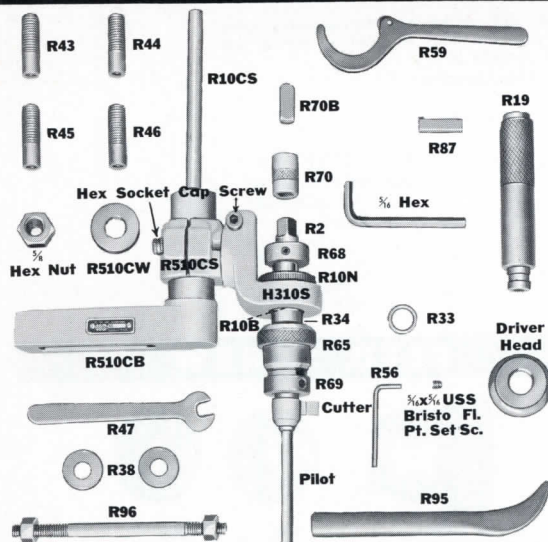
R2	Reseater Shank, 6 3/4" x 3/4" x 1" head
R19	Driver Handle
R20H	1 1/2" Driver Head
R22H	1 3/4" Driver Head
R24H	2" Driver Head
R28H	2 1/2" Driver Head
R33	Spacer Washer for Shank, 1/4" x 3/4"
R34	Spacer Washer for Shank, 1/2" x 3/4"
R38	Two Hardened Washers for Rod
R43	7/16" U.S.S. Stud Extension
R44	7/16" S.A.E. Stud Extension
R45	1/2" U.S.S. Hardened Stud Extension
R46	1/2" S.A.E. Hardened Stud Extension
R47	"S" Wrench for Pilots

R56	Set Screw Wrench
R59	Spanner Wrench
R65	Screw Feed Attachment (Consists of R66 Feed Nut with bearing and R67 Feed Screw)
R68	Stop Collar with Set Screw
R69	Stop Collar with Raised Bar
R70	Coupling
R70B	Drive Bar
R87	Clincher, 1 1/2" long
R88	Clincher, 2 3/8" long
R95	Ring Extractor
R96	Threaded Clamp Rod with Nuts
R101 to R112	Twelve Cutters
R210	5/16" Standard Pilot
R210P1	5/16" +.001 Pilot
R210P2	5/16" +.002 Pilot

Shipping Weight 34 lbs.

R211	11/32" Standard Pilot
R211P1	11/32" +.001 Pilot
R211P2	11/32" +.002 Pilot
R212	3/8" Standard Pilot
R212P1	3/8" +.001 Pilot
R212P2	3/8" +.002 Pilot
R213M9	13/32" —.009 Pilot
R213	13/32" Standard Pilot
R214	7/16" Standard Pilot
R216	1/2" Standard Pilot
R219	19/32" Standard Pilot
R220	5/8" Standard Pilot
R233	1 1/32" Pilot for Ford V8-85
R504BA	Box only
R504T	Tray
R510	Universal Guide
KO-17	Data Plate
	5/8" Hex. Nut

R500 BASIC RESEATER SET



This set is designed to service any one model of car, truck, or tractor from the smallest to the largest, regardless of cylinder block style.
NOTE: The R500 Basic Set DOES NOT include Pilots, Driver Heads or Cutters for Rings. It is necessary that the purchaser order these items separately, specifying desired size of each for use on selected motors.
Model R500 Basic Reseater Set consists of the following items:

R2	Reseater Shank, 6 3/4" x 3/4" x 1" head
R19	Driver Handle
R33	Spacer Washer
R34	Spacer Washer
R38	Two Hardened Washers
R43	7/16" U.S.S. Stud Exten.
R44	7/16" S.A.E. Stud Exten.
R45	1/2" U.S.S. Hardened Stud Extension
R46	1/2" S.A.E. Hardened Stud Extension
R47	"S" Wrench for Pilot
R56	Set Screw Wrench
R59	Spanner Wrench

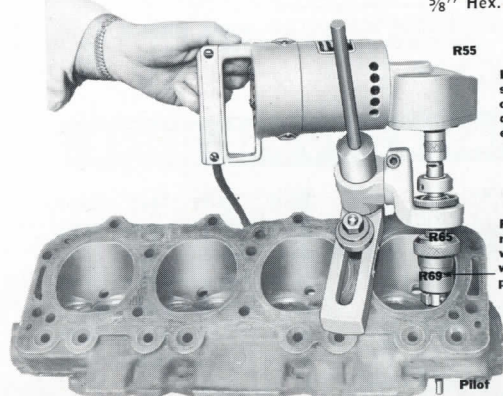
R65	Screw Feed Attachment (Consists of R66 Feed Nut with bearing and R67 Feed Screw)
R68	Stop Collar with Set Sc.
R69	Stop Collar with Raised Bar
R70	Coupling
R70B	Drive Bar
R87	Clincher, 1 1/2" long
R95	Ring Extractor
R96	Clamp Rod
R504BA	Box only
R504T	Tray
R510	Universal Guide
KO-17	Data Plate
	5/8" Hex. Nut

R502 JUNIOR RESEATER SET

Designed to service 90 per cent of all cars, trucks and tractors; includes equipment for clinching and extracting rings. Additional cutters, pilots and other accessories may be subsequently purchased when needed.

Model R502 Junior Reseater Set consists of the following items:

R2	Reseater Shank, 6 3/4" x 3/4" x 1" head
R19	Driver Handle
R20H	1 1/2" Driver Head
R24H	2" Driver Head
R33	Spacer Washer for Shank, 1/4" x 3/4"
R34	Spacer Washer for Shank, 1/2" x 3/4"
R38	Two Hardened Washers for Rod
R43	7/16" U.S.S. Stud Extension
R44	7/16" S.A.E. Stud Extension
R45	1/2" U.S.S. Hardened Stud Extension
R46	1/2" S.A.E. Hardened Stud Extension
R47	"S" Wrench for Pilots
R56	Set Screw Wrench
R59	Spanner Wrench
R65	Screw Feed Attachment (Consists of R66 Feed Nut with bearing and R67 Feed Screw)
R68	Stop Collar with Set Sc.
R69	Stop Collar (Raised Block)
R70	Coupling
R70B	Drive Bar
R87	Clincher, 1 1/2" long
R95	Ring Extractor
R96	Clamp Rod with Nuts
R101 to R107	Seven Cutters
R210	5/16" Standard Pilot
R211	11/32" Standard Pilot
R212	3/8" Standard Pilot
R213	13/32" Standard Pilot
R213M9	13/32" —.009 Pilot
R219	19/32" Standard Pilot
R233	1 1/32" Ford V8-85 Pilot
R504BA	Box only
R504T	Tray
R510	Universal Guide
KO-17	Data Plate
	5/8" Hex. Nut



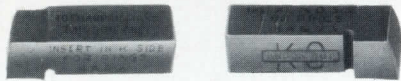
K. O. Lee Reseater shown in operation on a late extreme angle valve-in-head engine.

R69 Stop Collar with raised bar is used when R65 feed nut will not enter valve port.

K. O. LEE COMPANY, ABERDEEN, SO. DAKOTA

K. O. Lee RESEATER ACCESSORIES

RESEATER CUTTERS



K-O Reseater Cutters are made from high speed tool steel. Recesses are accurately cut with K-O cutters. There are no adjustments to be made; simply insert cutter in Reseater Shank, press firmly against shoulder of the cutter and lock with set screw. Each K-O cutter is made to accommodate two or more ring sizes.

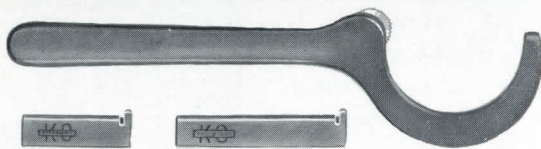
Cutter No.	For Ring Diameters "O" Side "K" Side	Cutter No.	For Ring Diameters "O" Side "K" Side
R 98.....	15/16" 1"	R110.....	2- 7/16" 2 1/2"
R 99.....	1- 1/16" 1 1/8"	R111.....	2- 9/16" 2 3/8"
R100.....	1- 3/16" 1 1/4"	R112.....	2-11/16" 2 3/4"
R101.....	1- 5/16" 1 3/8"	R113.....	2-13/16" 2 7/8"
R102.....	1- 7/16" 1 1/2"	R114.....	2-15/16" 3"
R103.....	1- 9/16" 1 5/8"	R115.....	3- 1/16" 3 1/8"
R104.....	1-11/16" 1 3/4"	R116.....	3- 3/16" 3 1/4"
R105.....	1-13/16" 1 7/8"	R117.....	3- 5/16" 3 3/8"
R106.....	1-15/16" 2"	R118.....	3- 7/16" 3 1/2"
R107.....	2- 1/16" 2 1/8"	R119.....	3- 9/16" 3 5/8"
R108.....	2- 3/16" 2 1/4"	R120.....	3-11/16" 3 3/4"
R109.....	2- 5/16" 2 3/8"		

NOTICE: Shank RO and Feed Screw R67S must be used with R98 and R99.

RESEATER PILOTS

No.	Size	No.	Size
R208 1/4" Standard Pilot		R212P15 3/8" +.015 Pilot	
R208S 1/4" Short Pilot		R212P30 3/8" +.030 Pilot	
R208M14 6mm Pilot		R213M2 13/32" —.002 Pilot	
R208P6 6.5mm Pilot		R213M9 13/32" —.009 Pilot	
R209 9/32" Standard Pilot		R213M12 10mm Pilot	
R209S 9/32" Short Pilot		R213 13/32" Standard Pilot	
R209M5 7mm Pilot		R214M1 7/16" —.001 Pilot	
R209P15 7.5mm Pilot		R214M2 7/16" —.002 Pilot	
R210M1 5/16" —.001 Pilot		R214 7/16" Standard Pilot	
R210M2 5/16" —.002 Pilot		R214P1 7/16" +.001 Pilot	
R210 5/16" Standard Pilot		R214P2 7/16" +.002 Pilot	
R210P1 5/16" +.001 Pilot		R215 15/32" Standard Pilot	
R210P2 5/16" +.002 Pilot		R215P3 12mm Pilot	
R210P3 8mm Pilot		R216M1 1/2" —.001 Pilot	
R210P4 5/16" +.004 Pilot		R216M2 1/2" —.002 Pilot	
R210P15 5/16" +.015 Pilot		R216 1/2" Standard Pilot	
R210P30 5/16" +.030 Pilot		R216P1 1/2" +.001 Pilot	
R211M1 11/32" —.001 Pilot		R216P2 1/2" +.002 Pilot	
R211M2 11/32" —.002 Pilot		R217 17/32" Standard Pilot	
R211M3 11/32" —.003 Pilot		R217M1 17/32" —.001 Pilot	
R211M9 8.5mm Pilot		R217P1 17/32" +.001 Pilot	
R211 11/32" Standard Pilot		R218 9/16" Standard Pilot	
R211P1 11/32" +.001 Pilot		R218P1 9/16" +.001 Pilot	
R211P2 11/32" +.002 Pilot		R218P2 9/16" +.002 Pilot	
R211P3 11/32" +.003 Pilot		R219 19/32" Standard Pilot	
R211P10 9mm Pilot		R220 5/8" Standard Pilot	
R211P15 11/32" +.015 Pilot		R220P1 5/8" +.001 Pilot	
R211P30 11/32" +.030 Pilot		R222 11/16" Standard Pilot	
R212M1 9.5mm Pilot		R222P1 11/16" +.001 Pilot	
R212M2 3/8" —.002 Pilot		R222P2 11/16" +.002 Pilot	
R212 3/8" Standard Pilot		R224 3/4" Standard Pilot	
R212P1 3/8" +.001 Pilot		R226 13/16" Standard Pilot	
R212P2 3/8" +.002 Pilot		R227P6 .850" Ford Pilot	
R212P5 3/8" +.005 Pilot		R233 1-1/32" Ford Pilot	

RING CLINCHER EQUIPMENT

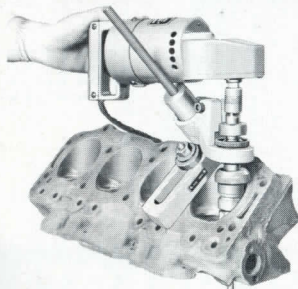


R87 Clincher for rings up to K-O No. 18, 1 1/2" long
R88 Clincher for rings K-O No. 19 and larger, 2 3/8" long
R59 Spanner Wrench for Screw Feed

SPECIAL ACCESSORIES FOR USE ON MODEL RE101-A MINNEAPOLIS MOLINE MOTOR

R10CM Guide Casting only
R12M Raising Block

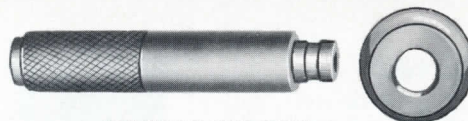
R55B INSERT POWER DRIVE



R55B Valve Seat Insert Power Drive is rugged, heavy duty, precision built. Provides adequate power for all jobs. Gets the work done in a hurry. Can be used with all K. O. Lee reseater sets in the field.

Available with 1115 or 230 volt Universal motor.

DRIVER HANDLE AND DRIVER HEADS



FOR VALVE SEAT RINGS

K-O Driver Handle and Heads are hardened. The handle is tapped so that a pilot can be screwed in to serve as a guide when driving rings.

R15H Driver Head, 15/16" x 3/4"	R24H Driver Head, 2" x 3/4"
R16H Driver Head, 1" x 3/4"	R25H Driver Head, 2 1/8" x 3/4"
R17H Driver Head, 1 1/8" x 3/4"	R26H Driver Head, 2 1/4" x 3/4"
R18H Driver Head, 1 1/4" x 3/4"	R27H Driver Head, 2 3/8" x 3/4"
R19 Driver Handle, 1 1/4" x 6"	R28H Driver Head, 2 1/2" x 3/4"
R19H Driver Head, 1 3/8" x 3/4"	R29H Driver Head, 2 3/4" x 3/4"
R20H Driver Head, 1 1/2" x 3/4"	R30H Driver Head, 3" x 3/4"
R21H Driver Head, 1 5/8" x 3/4"	R31H Driver Head, 3 1/8" x 3/4"
R22H Driver Head, 1 3/4" x 3/4"	R32H Driver Head, 3 1/2" x 3/4"
R23H Driver Head, 1 7/8" x 3/4"	

(Each driver head includes one 5/16" x 5/16" flat point Bristo set screw.

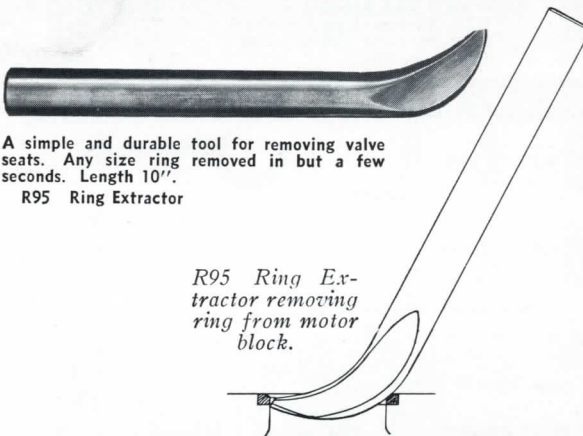
RESEATER SHANKS

K-O Reseater Shanks are hardened and precision ground. The head of the shank is ground flat on opposite sides, against which the cutter bears. One flat surface is stamped "O"; the other "K." The "O" side is ground 1/32" more than the "K" side, thereby permitting a cutter inserted in the "K" side to cut a recess 1/16" larger than when inserted in the "O" side. Therefore a cutter, used in a K-O shank will cut two different size recesses, each serving several different rings.

R0 Reseater Shank, 6 3/4" x 3/4" x 3/4" head
R1 Reseater Shank, 4 1/2" x 3/4" x 1" head
R2 Reseater Shank, 6 3/4" x 3/4" x 1" head
R3 Reseater Shank, 8" x 3/4" x 1" head

Above Reseater Shanks are available for cutting .005, .010, .015, .020, .030 and .045 oversize recess, utilizing standard cutters. To order specify shank and oversize, as R2+.010.

VALVE SEAT RING EXTRACTORS

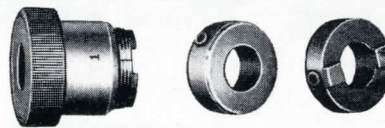


A simple and durable tool for removing valve seats. Any size ring removed in but a few seconds. Length 10".

R95 Ring Extractor

R95 Ring Extractor removing ring from motor block.

FEED SCREW



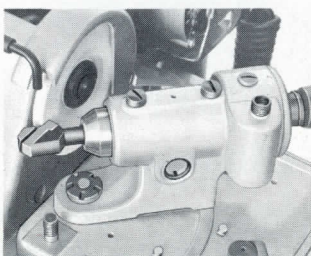
R65

R68

R69

R65 Screw Feed Attachment (Consists of R66 Feed Nut with bearing and R67 Feed Screw)
R67 Feed Screw
R67S Feed Screw (For use with R0 Shank and R99 Cutter) fits in R65 screw seat attachment.
R68 Stop Collar. R69 Stop Collar with raised blocks.

K37 SHARPENING FIXTURE



K. O. Lee reseater cutters are easily reshaped with the sharpening fixture (K37) which holds the cutter in position in the workhead. Disconnect cable from workhead during cutter sharpening operation.